

**MARLBORO STANDARDIZATION**

**TEST PLAN - RUN NO. 6**

**PREPARED BY THE**

**MARLBORO STANDARDIZATION GROUP**

**PM3000396656**

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**SECTION I - INTRODUCTION**

Plans are to conduct Marlboro Standard Run No. 6 at the four cigarette factories and at the Semiworks during the week of October 31, 1988. Plans for each factory and the Semiworks are covered in following sections of this document.

**OBJECTIVES OF RUN NO. 6:**

1. Confirm the trends of panel results obtained from the monthly pickups and previous standard runs.
2. Confirm the baseline with regard to formula changes and blend changes.
3. Compare the results while using the same direct cigarette materials at all factories.
4. Compare processing profiles with regard to temperatures, OVs, sieve and times.
5. Compare cigarette with regard to normal cigarette physical data such as CV, OV, weight, firmness, loose ends, etc., as reported by factory QA tests.
6. Compare analytical data.

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**SECTION II - TEST PLAN DESCRIPTION**

1. M/C Primary using DET10MS, no rippers, and other MS components, will make 40,000 pounds each of KS and LS cut filler. M/C Cigarette Manufacturing, using the cut filler and standardization packing materials, will make and pack at least 1 million each of KS and LS cigarettes for sampling.
2. Louisville plan is the same as M/C plan except Primary will use DET10MS produced at Cabarrus for MS Run No. 6.
3. S/S plan is the same as M/C except Primary will process 20,000 pounds of KS cut filler only.
4. Cabarrus plan is the same as M/C except that Cabarrus will produce its own DET10MS.
5. R&D Semiworks plan is to use MS components from the M/C to produce 1,000 lb of cut filler and MKS cigarettes using standardization packaging materials.
6. The four factories and the Semiworks should run with the same cigarette direct materials for this standard test only. See Section IV.
7. See SECTION VII - Sampling Requirements.

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**SECTION III - STANDARD MS COMPONENTS**

1. The respective processing plants will produce and provide the following:

- DET10MS (M/C for M/C, S/S, and Semiworks; Cab for Cabarrus and Louisville)
- ESMS
- ESB - 10 MS (Annex for Lvle and Cab; M/C for M/C and S/S)
- MTMS
- RCB10MS
- RLB10MS
- RL10MS
- Flavor concentrates
- Tipping paper

2. No ripper shorts will be used in the DET10MS.
3. Bright and Burley will be normal DBC per blend sheets using the *November/December formulas*.
4. See Section VII - Sampling Requirements

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**SECTION IV - STANDARD DIRECT MATERIALS**

1. Each cigarette fabrication facility will receive standardization packaging materials of the same lot divided among the locations:

- Tipping paper
- Cigarette paper
- Roll labels
- Blanks
- Inner-frame
- Foil-Soft pack
- Foil-Box
- Film
- Tear Tape
- Carton blanks
- Tow
- PZ
- Plug wrap
- Adhesives
  - Anchorline
  - Plug Lap
  - Side Seam
  - Tipping

2. See Appendix I for MKS materials specification.
3. See Appendix II for MLS materials specification.

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**SECTION V - PRIMARY**

1. A list of standard components and materials to be furnished is shown in Section II and IV.
2. All locations shall use no rippers in the finished filler.
3. See Section VII - Sampling Requirements.
4. See Appendices III and IV for the data forms which delineate the data required from Marlboro Standard Run No. 6. Enter the required data on a data diskette to be provided by the Marlboro Standardization Group and send a copy of the diskette to R. M. Jones, R&D E2, Richmond.
5. OV data shall be the average of at least 3 determinations.
6. Temperatures shall be the average of at least 3 determinations using a "heat gun" aimed at the center of the tobacco immediately at the exit of the equipment. Exercise care when obtaining these temperatures.
7. The target filler OV entering the cut filler dryers will be 21%.

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**SECTION VI - FABRICATION**

1. See Section IV and Appendices I and II for a list of standard packaging materials to be provided.
2. See Section VII - Sampling Requirements.
3. Prior to collecting cigarette samples, empty the Oscar, purge the module and restart to assure sample cigarettes are made from the test filler and standardization packaging materials.
4. For each maker/packer/module, record the following information and send a copy to J. F. Sherwood, O/C, A1E, Richmond:
  - Module/maker/packer identification
  - Time and date of sample collection
  - Sample identification
  - Maker speed
  - Side seam identification
  - Tipping adhesive identification
  - Label/blank adhesive identification
  - Heater temperature.
5. See Appendix IV for the data form which delineates the data required from Marlboro Standard Run No. 6. Enter the data on a data diskette to be provided by the Marlboro Standardization Group. Send a copy of the data diskette to R. M. Jones, R&D, E2, Richmond.

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SECTION VII - SAMPLING REQUIREMENTS

1. The Flavor Center will send a one quart sample of each flavor concentrate to:

K. S. Deane  
Operations Center, Door 104, Gate S  
2000 Bells Road  
Richmond, VA

2. Sample Containers and Labels - Labeled sample containers will be supplied to each location for the following:

- Burley spray
- Burley top casing
- Bright casing
- After cut flavor

Identifying labels will be supplied for the 12M cigarette cases.

3. Primary Processing - for each cut filler produced, take samples as follows and send to K. S. Deane, address as above:

- Burley spray (frozen) - 1 qt.
- Bright casing (frozen) - 1 qt.
- Burley top casing - 1 qt.
- After cut flavor - 1 qt.

4. Cigarette Manufacturing:

Cigarette Samples

<u>Factory</u>	<u>Number of 12M Cases</u>	
	<u>KS</u>	<u>LS</u>
MC	25	25
Stockton Street	25	--
Louisville	25	25
Cabarrus	25	25
Semiworks	26	--

Send cigarette samples to:

J. H. Warren  
Operations Center, Door 104, Gate S  
2000 Bells Road  
Richmond, VA

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APPENDIX I  
Marlboro KS Std. Run 6 Specifications

<u>Item</u>	<u>Lot Date</u>	<u>MC</u>	<u>Lvl</u>	<u>S/S</u>	<u>Cap</u>	<u>S/W</u>
PZ		Celanese	Same	Same	Same	Same
Tow		Celanese	Same	Same	Same	Same
Plug Wrap	9/12	06-157-A Ecusta 612	Same	Same	Same	
Tipping		12-431-K Ecusta	12-436-B	Same	12-436-B	Same
Cig. Paper	9/9	10-135-A	Same	Same	Same	Same
Labels	9/22	4L-291A Col. Hts.	Same	Same	Same	4L-290A Col. Hts.
Closure	9/6	40-101B J. W. Ferg.	Same	Same	Same	40-100E J.W. Ferg.
Foil	9/28	15-160A Reynolds	Same	Same	Same	Same
Film	9/6	44-198B Hoechst	Same	Same	Same	Same
Tear Tape	9/6	47-160A Arlin	Same	Same	Same	Same
Carton	9/19	C-290A Va. Fold Box	Same	Same	Same	Same
Case	9/12	54-290T Weyerhaeuser	Same	Same	Same	Same
Adhesives:						
Anchorline		61-007-A (Polymer 255-11)	Same	Same	Same	Same
Plug Lap		61-428-A (Fuller HM-8229CH)	Same	Same	Same	Same
Sideseam		61-444-A (Fuller WB-3902U)	Same	Same	Same	Same
Tipping		62-050-A (Findley 355-381-01)	Same	Same	Same	Same

Note: Same means same as M/C.

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**APPENDIX II**  
Marlboro LS Std. Run 6 Specifications

<u>Item</u>	<u>Lot Date</u>	<u>MC</u>	<u>Lvl</u>	<u>Lab</u>
PZ		Celanese	Same	Same
Tow		Celanese	Same	Same
Plug Wrap	9/19	06-251-A KC 45 M1	Same	Same
Tipping		12-418-F KC GSR-98	Same	Same
Cig. Paper	9/9	10-023-A	10-135-A	Same
I-Frame	9/8	20-001A Westvaco	Same	Same
Box Blank	10/3	4F-018A Va. Fold Box	Same	Same
Foil	8/29	15-125A Alcan	Same	Same
Film	9/20	44-154A Hercules	Same	Same
Tear Tape	9/6	47-160A Arlin	Same	Same
Carton	9/27	C-014A Rich. Gravure	Same	Same
Case	9/12	54-012P Nekoosa	Same	Same
<b>Adhesives:</b>				
Anchorline		61-007-A (Polymer 255-11)	Same	Same
Plug Lap		61-428-A (Fuller WB-3902U)	Same	Same
Sideseam		61-444-A (Fuller WB-3902U)	Same	Same
Tipping		62-050-A (Findley 355-381-01)	Same	Same

Note: Same means same as M/C.

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**APPENDIX III  
DATA FORM  
PRIMARY PROCESS**

The following data form - 6 pages - delineates the process data to be taken and reported for Marlboro Standard Run No. 6 beginning with hlds/containers entering the Vacuum Conditioners and ending with cut filler exiting the cutters. These data are common to all locations and both king and long size cigarette filler processing.

Note especially the requirement to select hlds/containers of specific grades of Bright and Burley and hlds/containers of other components at the entrance to Vacuum Conditioning. The intent is that the selected hhd/container be followed through the process up to and including entry into the hhd/container feeder.

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